

Work Order ID 70301

Thursday, June 02, 2011 1:52:49 PM



Page 1

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/8/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3209	Rev A

100 0.00

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

110



HAAS CNC VERTICAL MACHINING #1

HAAS I

HAAS CNC vertical machine #1

Memo

0.00

Machine D3209-1 as per Folio FA345 and Dwg D3209-1 Identify as D3209-1

||

Deburr and Tumble

120



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70301

Thursday, June 02, 2011 1:52:49 PM



Page 2

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/8/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC8- Inspect parts - second check

0.00

b.a 11/06/09

5 φ

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

5x φ m-f 11/06/10

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

0.00

Note: Cover the hole for D3209-1 before powder coat. START TIME: 11:00 FINISH TIME: 12:00 OVEN TEMPERATURE: 320° F

11/5/128

5x φ m-f 11/06/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 70301

Thursday, June 02, 2011 1:52:49 PM



Page 3

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/8/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

5 of 34 6/06/13

161



Small Fab

Small Fab

Memo

0.00

Memo

0.00

press fit bushing as per dwg

6/06/13 ③

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

6/06/14

④

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 70301

Thursday, June 02, 2011 1:52:49 PM



Page 4

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/8/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: *Small fab*

0.00

11/14/14 SL PS

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/16/14 MF

Memo

0.00

*MF
11-06-14*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:52:46 PM

Page 1

Work Order ID: 70301



Parent Item: D3209-041



Parent Item Name: Bracket Assembly

Start Date: 6/8/2011

Required Date: 6/24/2011

Comments: IPP AI 04.06.09 [New issue] KJ/RF

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3209-3



Manufactured

No

100

Each

39.0000

1

5

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

ST041

39

40930

39

M6061T6B1.500X01.25
0



Purchased

No

170

f

11.3278

0.175

0.921053

6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
----------	---------	----------

MAT004

11.3278

→107461
110936

0.9

10.4278

.9

✓ 6/8/11/06/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Action Description	Sign & Date			

NOTE: Date & initial all entries

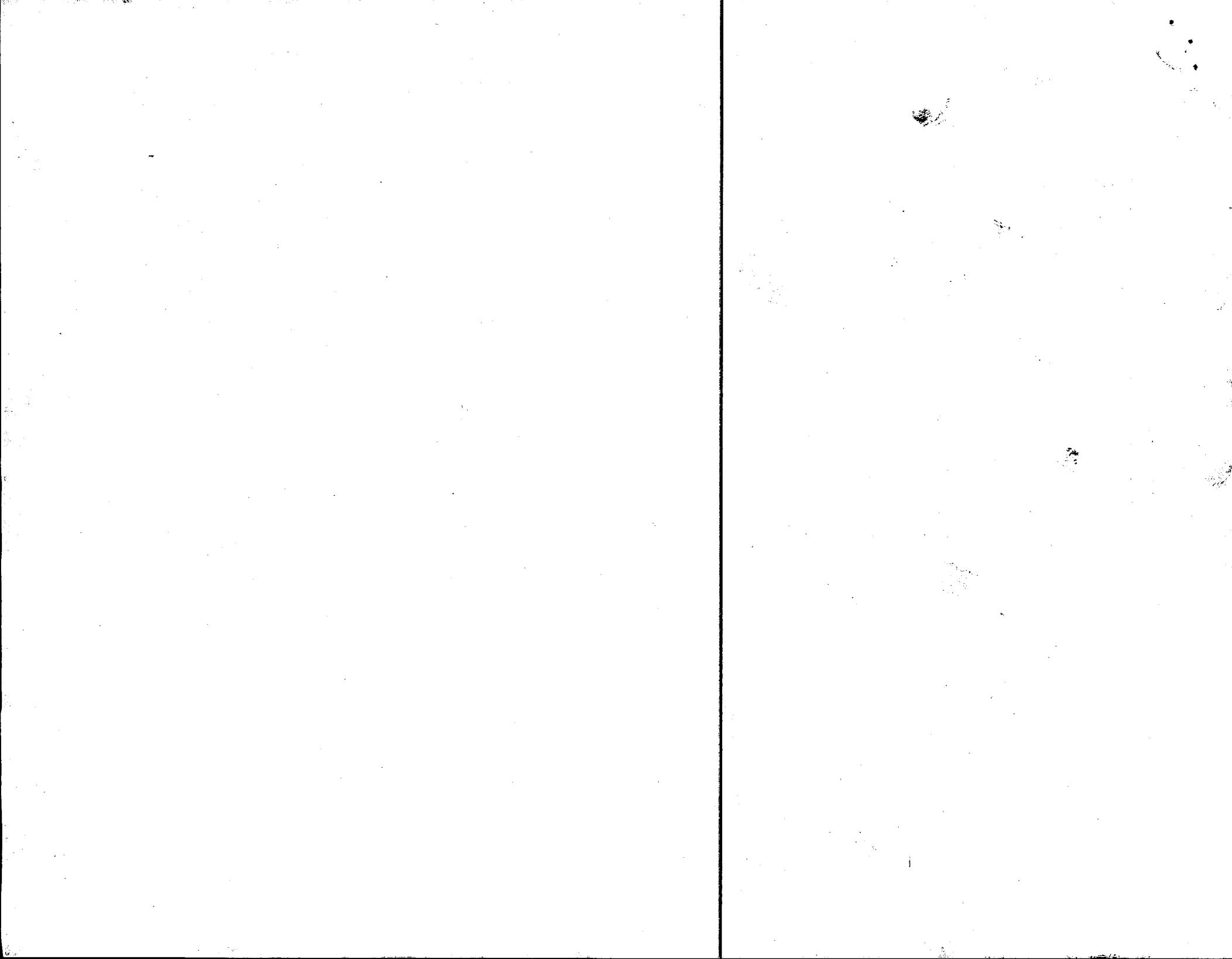
DART AEROSPACE LTD	Work Order:	7030/
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>ony</u>	Audited by:	<u>B.A.</u>	Prototype Approval:	N/A
Date:	<u>11/06/09</u>	Date:	<u>11/06/09</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	SJM



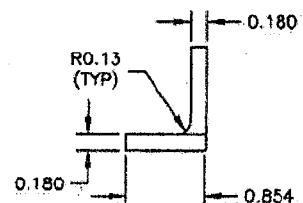
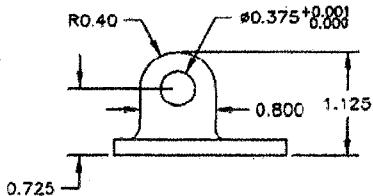
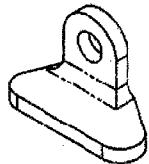
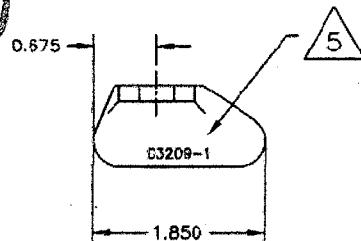


COPY ISSUED
TO

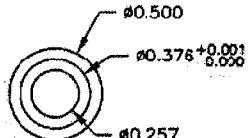
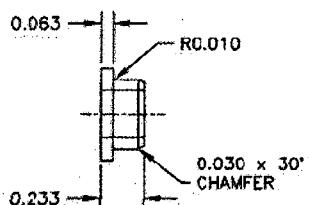
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*

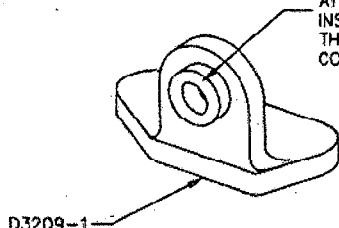
w/o 70301



2 D3209-1 BRACKET



D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



3 D3209-3 BUSHING
SCALE 1:2

4 D3209-041 ASSEMBLY

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

